

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023491**Date Inspected:** 07-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

TA YARD

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint no: SEG3020AH-002 [Side Panel (SP) 3144B to Edge Panel (EP) 3029A, Complete Joint Penetration (CJP) weld at panel point (PP) 125 to PP 127]. The welder is identified as 067949 and was observed welding in 2G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-T2232-ESAB.

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3020L-018 [Top anchorage plate (AP) 3015A/3016A to Floor Beam (FB) 3325A, Fillet weld at PP126]. The welder is identified as 066361 and was observed welding in 4F position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2114-FCM-1.

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The SMAW process on weld joint no: SEG3020T-117 [WT stiffener on top AP 3021A to FB 3319A, CJP weld at PP125.5]. The welder is identified as 067611 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

The SMAW process on weld joint no: SEG3020W-105 [I-rib stiffener on top AP 3016A to FB 3316A, CJP weld at PP125]. The welder is identified as 037779 and was observed welding in 3G position. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: B-P-2213-Tc-U4b-FCM-1.

Repair welding of weld joint no: SEG3020X-004 [Top AP 3017A to Longitudinal Diaphragm (LD) 3049A, CJP weld in between PP 125 to PP125.5]. The welder is identified as 045246 and was observed welding in the 4G position. Welding process was identified as SMAW. ZPMC QC was identified as Mr. An Qing Xiang. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-4G(4F)-FCM-Repair-1. Repair welding was done as per Welding Repair Report (WRR): B-WR 20845 Rev-0. See attached photograph for further details.

During random in process inspection this QA inspector observed that ZPMC personnel were removing temporary attachments from side panel (SP) 3140C by carbon air arc gouging. See attached photograph for further details.

During random in process inspection this QA inspector observed that ZPMC personnel were performing welding of dog plates on the top of the deck plates of segment 13CW and 14W for alignment of 13CW and 14W. The welder was identified as 066734 and ZPMC QC was identified as Mr. An Qing Xiang. See attached photograph for further details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
